Work Order ID	121228
Iuna 19 14 1.56.22 DM	

121228

Page 1

June-18-14 1:50	6:23 PM										
Item ID: Revision ID:	D3462-042			Accept	*N900	040	100)* s	Setup Start	14	S1*
Item Name:	Bracket Assem	bly							Stop	*N	S2*
Start Date:	6/18/14	Start Qty: 4.00	*4*		Cust Item	ID:					
Required Date:	6/18/14	Req'd Qty: 4.00	*4*		Customer:						
Reference:								_	G		
Approvals:	Process Plan	n: _ML5	Date: 14-06-18	Tooling:	D	ate:		R	Run Start	171	R1*
				SPC (Y/N):	D	ate:			Stop	*N	R2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr									
D3462	Rev	С									
100				0.00				ı		4	
100 Large Fab		Large Fab		0.00				4	$-\mathcal{A}$	14-	7-7
Large Fab		Memo Weld asse	embly as per dwg D3462	0.00							
i		•	<i>y</i> ,								
1											DAS
110		QC9- Inspect visual p	er QSI004- Fusion Welds	0.00				//	10	10-	7 24 7 9-89
110				0.00				4_			/ 5-59
QC Quality Control		Memo	•	0.00				1			
!											
								ſ			
120		QC5- Inspect part con	npleteness to step on W/O	0.00				1	0./	7 1	DAS 24 9- 8 9
120								7	14.	/	9-89
QC Quality Control		Memo		0.00					1-4	•	_
Quality Collifor											

DQA:			Date:			,								TART
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only		
Work Ord	or.			•		DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		
WOIK OIU	e1.					Rework	1	}	Skid-tube Crosstube	Г	1	Water Jet	7	Engineering
Part i	Vo.					Scrap			Machining Small Fab	_	Pro	d. Eng. Coor.	7	Quality
						Use-as-is	1		noforming Finishing	_	4	re/Packaging	1	Other
NCR I	۷o. ₋					Suspected Unapproved	1		Large Fab Composite]	Supplier		
Root					Desci	ription of work order update	<u> </u>	Initial	Action		Sign &	***		
Cause	l	Date	Step	Qty		or non-conformance		nief Eng	Description		Date	Verification	Ì	QC Inspector
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Doc/Data														
Equip/Tooling														
Handling/Pre	Ш											!		
Material	Ш													
Operator]										
Offset/Setup														
Process	Ш													
Supplier	Щ													
Training	H		ļ											•
Transport ASS Unapproved	Н					•								
	Ш		<u> </u>	<u> </u>	<u> </u>		<u> </u>	III T CA	TEGORY		<u> </u>	<u> </u>		
Landi			-	-		General	FA	OLI CA	ILGORI					
Lanui	$\overline{}$	Bending				Bend		Teolio/F	Program	Γ	Outside Dim	ensions	\neg_{P}	Pressure/Forced
	\vdash	Centre No	nt Concer	ntric	<u> </u>	BOM/Route	\vdash	Grain	108.4		Over/Under	<u> </u>	_	Set-up
	H	Cracks	or concer			Broken/Damage/Defect		Hardwa	are		Part Incorre	_		emperature/Cure
		Çrimp/Kir	nk/Ripple	e/Wave	-	Burrs		-	ion Incomplete/Unqualified		Part Lost/M	issing	_	Weld
	E.	Cuffs		,		Contamination		- i	tions Incomplete/Unclear		Part Moved		\neg	Wrong Stock Pulled
	740	Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	_	
		Heat Trea				Cut Too Short		Mislab			Power Loss/	Surge		Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Cl	natter			Drill Holes		Off-set						
		Turning S	equence			Finish		_	Calibration					
		Wave/Tw	ist in Tub	be		Fit/Function		Out of	Sequence					

W	ork	Order	· ID	121228
T T	VI N	V) UCI		141440

121228

Page 2

June-18-14 1:5	6:23 PM			1/1/	<i></i>						
Item ID: Revision ID: Item Name:	D3462-042 Bracket Asse			Accept	*N900	040	100)*	Setup Star	10'-2	* *
Start Date: Required Date Reference:	6/18/14	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item II Customer:	D:					
Approvals:		lan:	Date:	Tooling: SPC (Y/N):		ite:]	Run Start Stop	^IVIH	
Sequence ID/ Work Center I 130 *120* Powdercoat Powder Coating 140 *140* QC Quality, Control	D	Operation Description White Gloss(Ref:4.3.5.2) Memo START TIM QC3- Inspect Part Finish Memo	E: 3 20 (FINISH TIME:	Set Up/ Run Hours 0.00 0.00 0.00 0.00 0.00 0.00 0.00 0.00 0.00	Tool ID DAS 27 9-89	Tool#	Plan Code	Accept Qty 4	Reject Qty	Reject Ins Number Sta	ip.
150 *150* Packaging Packaging		Identify as per dwg & St	ock Location: <u>ST5</u> 4,	/ 0.00 0.00				_4x	DAS 28 9-8		014

DQA:			Date:										TART
						WORK ORDER NON-	·CC	ONFO	RMANCE / UPDATE			_	AEROSPACE
QA Closed:			Date:					· · · · · · · · · · · · · · · · · · ·		W	ork Order up	date only	
Work Orde	or.					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	
WOIK OIG	٠,,				_	Rework			Skid-tube Crosstube			Water Jet	Engineering
Part N	No.					Scrap			Machining Small Fab	_	Pro	d. Eng. Coor.	Quality
	•					Use-as-is			noforming Finishing		1	re/Packaging	Other
NCR I	No.					Suspected Unapproved			Large Fab Composite			Supplier	
Root					Desci	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
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Doc/Data													ĺ
Equip/Tooling													
Handling/Pre													
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Offset/Setup													
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			or concer	itric		Broken/Damage/Defect	┝	Hardwa	ara	-	Part Incorre	<u> </u>	Temperature/Cure
411	5 1	Cracks Crimp/Kir	nk/Rinnle	/\\/ava	-	Burrs	┢	4	ion Incomplete/Unqualified		Part Lost/Mi	 	Weld
	-	Cuffs	ik/ hippie	, wave		Contamination	\vdash	1	tions Incomplete/Unclear	\vdash	Part Moved	-	Wrong Stock Pulled
	\vdash	Crushing			\vdash	Countersink		4	gned/off center		Positioned V	∟ Vrong	
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	_	Inspectio		Tube	-	Drawing		Misrea		_	<u>'</u>	· _	•
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		Turning S				Finish		Out of	Calibration				
		Wave/Tw				Fit/Function		Out of	Sequence				

Wo	rk	Order	· ID	121228
VV U	11 K	Oluti		141440

121228

Page 3

June-18-14 1:56:23 PM

Required Date: 6/18/14

Item ID:

D3462-042

Accept

N900040100

Setup Start

Stop

Revision ID:

Item Name: Start Date:

Bracket Assembly

6/18/14

Start Oty: 4.00

4

Cust Item ID:

Req'd Oty: 4.00 *4* Customer:

Reference:

Approvals:

QC:

Process Plan:

Date: Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start

Run

Stop

Sequence ID/ Work Center ID Operation

Description

Set Up/ Run Hours Tool ID

Tool # Plan Code Accept Qty

Reject Qty

Reject Number

Insp. Stamp

160

160

QC

Memo

OC21- Final Inspection - Work Order Release

0.00

0.00

Quality 'Control

DQA:			Date:	<u></u>									"DART
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO		Wo	rk Order up	date only	AEROSPACE
QA Closea.			Dute.								•		
Work Ord	er:					DISPOSITION			AGAINSTI	DEP	ARTMENT	PROCESS	
	-					Rework			Skid-tube Crosstube	Д.		Water Jet	Engineering
Part N	۷o					Scrap			Machining Small Fab	_		d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming Finishing	_	Rec/Stor	e/Packaging	Other
NCR I	۱o. ₋				<u> </u>	Suspected Unapproved			Large Fab Composite			Supplier	J · LJ
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		Bending			-	Bend	<u> </u>	1	Program	-	Outside Dim	· .	Pressure/Forced
٠	Н	Centre No	ot Concer	ntric		BOM/Route	┢	Grain		-	Over/Under	—	Set-up
	\vdash	Cracks		4	<u> </u>	Broken/Damage/Defect		Hardwa	· • • • • • • • • • • • • • • • • • • •		Part Incorred Part Lost/Mi	-	Temperature/Cure Weld
	_	Crimp/Kir	nk/Ripple	/Wave	\vdash	Burrs		4 `	ion Incomplete/Unqualified	-	Part Lost/Will Part Moved	ssirig .	Wrong Stock Pulled
	-	Cuffs			-	Countaries	<u> </u>	4	tions Incomplete/Unclear	-	Positioned V	/rong	I wrong stock runed
	\vdash	Crushing	•		-	Countersink Cut Too Short	-	Mislabe	gned/off center	_	Positioned v		Other
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	\vdash	Wave/Tw	-		-	Fit/Function		4	Sequence	-			
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Page 1

Work Order ID: 121228

121228

Parent Item:

D3462-042

D3462-042

Parent Item Name:

Bracket Assembly

Start Date: 6/18/14

Required Date: 6/18/14

Start Qty: 4.00

Required Qty: 4.00

Comments:

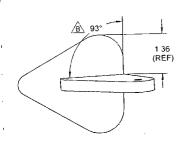
IPP REV. A 05.11.18 NEW ISSUE

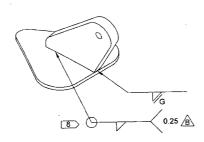
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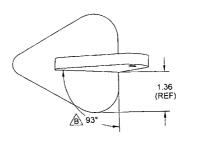
esr rev B 08.07.15 ecn 1049 EC verified by: DD

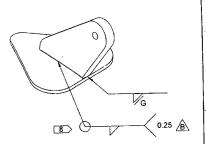
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3462-;1		Manufactured	No		· · · · · · · · · · · · · · · · · · ·	100	Each	10.0000	. 1	4	-		
D3462-1 Bracket Assembly									**	\mathcal{A}	/4	1-7-	7
•				Location		Loc	<u>Otv</u>	Loc Code					
1				WA002			10		· <u> </u>				
				1	101445		10			4_			
D3462-3	:	Manufactured	No	-		100	Each	19.0000	1	4			
D3462-3	u.								**	E	14.	7-7)
Lug				Location		Loc	Oty	Loc Code					
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1					100436 107653		7 12			3			

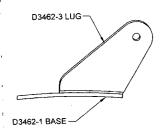
DQA:			Date:											"DART
						WORK ORDER NON	-CC	ONFO	RMANCE / UI			_		AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
WOIK OIG	٠٠.			-	—	Rework	1		Skid-tube	Crosstube	7	Water Jet		Engineering
Part I	۷o.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	\neg	Quality
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Root					Desc	ription of work order update		nitial	Act	ion	Sign &			
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	\vdash	Crimp/Ki	nk/Rinple	/Wave		Burrs		4	ion Incomplete/Ur	ngualified	Part Lost/Mi	}		Weld
		Cuffs	ypp.c	,,		Contamination		-l '	tions Incomplete/L	· —	Part Moved			Wrong Stock Pulled
		Crushing				Countersink		-	gned/off center		Positioned V	ر Vrong		
	 	Heat Tre				Cut Too Short		Mislabe	-		Power Loss/			Other
		Inspectio		Tube		Drawing		Misrea		L	-			
l		Marks/Cl	-			Drill Holes		Off-set						
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		Wave/Tv				Fit/Function		Out of	Sequence					



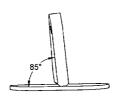


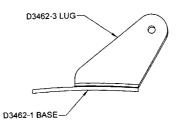






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D3462-041 BRACKET ASSEMBLY

SHOP COPY RETURN 10 **ENGINEERING** UNCONTROLLED COL SUBJECT-TO AMENDME[®] WITHOUT NOTICE

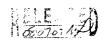
WORK ORDER NO_121228_ML3

1406-18

QTY -041	-042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	х	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042"
USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.75 ibs (TYP)
8) WELDING: PER DART QSI 004

D3462-042 BRACKET ASSEMBLY



С	SHOW	VIEWS OF D346	2-041 & D3462-042, UPDATE DWG N FACILITY	DC	07.10.24
В.		DIMENSIONS		RF	05.12.05
	NEW IS	SUE		RF	05.09.20
REV.	1	RIPTION		BY	DATE
DESIG			DART AEROSP		
DRAW	N	VI AND DC	HAWKESBURY, ONTAF	RIO, CANA	DA
CHECK	(FD	111	DRAWING NO.		REV. C

D3462 SHEET 1 OF 2 MFG. APPR. SCALE TITLE APPROVED **BRACKET ASSEMBLY** 1:2 DE APPR. DATE 07.10.24

COPYRIGHT © 2305 BY DART AEROSPACE LTD
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60° (TYP) 3.36 R0.82 (TYP) D3462-1F FLAT PATTERN

R0.55 -- 0.375 2.55 -Ø0.257 (DRILL "F") 1.98 - R20.0±0.1 R0.50 -0.08 X 45° CHAMFER — (TYP)

D3462-3 LUG

- R20.0±0.1

D3462-1 BEND DETAIL (MAKE FROM D3462-1F)

NOTES: 1) MATERIAL: AISI 304 SS SHEET, 0.125 THICK PER MIL-S-5019 (ANNEALED), 2B FINISH (REF. DART SPEC. M304S11GA)

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.28 lbs

NOTES:
1) MATERIAL: AISI 304 SS BAR
(REF. DART SPEC M304B0.375X03.000)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.47 lbs



DESIGN	*	DART AEROSPACE LTD	
DRAWN	100 2.C	HAWKESBURY, ONTARIO, CA	NADA
CHECKED	luter	DRAWING NO.	REV. C
MFG. APPR.	20	D3462	SHEET 2 OF 2
APPROVED	100.0	TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY_	1:1
DATE 07.10.24		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPRENENT AND ISSUED IS SUPPLY OF THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COMPANION TO TO ANY OTHER PERSON INTRICUT.	

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